

Work Order ID 75218

75218

Page 1

October-19-11 11:07:18 AM

Item ID: D3368-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tail Rotor Pedal Disabling Kit
 Start Date: 19/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3368	Rev B								

100 0.00
100 Small Fab
 Small Fab Memo 0.00
 Small Fab 1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest. 2-Fabricate D3371-5 Cam Lock as per Dwg D3371 Identify as D3371-53-Assemble lock mechanism and cam and install decal as per Dwg D3368. (4) FE 12-03-08

110 0.00
110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00 5.7/13/09 (4)

120 0.00
120 Identify as per dwg & Stock Location: ST 491
 Packaging Memo 0.00 (4) SP 12-03-B-

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

11203-14

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NOTE: Date & initial all entries

Picklist Print

October-19-11 11:07:23 AM

Page 1

Work Order ID: 75218

75218

Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Disabling Kit

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A Removed from 9 Digit 06-03-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 *238-028* 3/16" Dowel Pin .5" long		Purchased	No			100	Each	224.0000	2	8			
										**	(4) FF 12-03-08		
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST399	224						
						106673	98						
						<u>108114</u>	99		8				
						17848	27						
385-039 *385-039* 8-32 Flat screw		Purchased	No			100	Each	83.0000	4	16			
										**	(4) FF 12-03-08		
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST401	83		16				
						<u>110935</u>	83						
AN960-416 *AN960-416* Washer	NAS1149F0463P	Purchased	No			100	Each	0.0000	2	8			
										**	8 (4) FF 12-03-08		
CBL-1240 *CBL-1240* Cable		Purchased	No			100	f	925.4014	2.3333	9.3332			
										**	(4) FF 12-03-08		
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	500						
						119021	500						
						ST284	425.401431						
						113565	6.311789						
						116438	119.089642						
						118207	300						
						119690			9.3332				

✂

120739

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 75218

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Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Disabling Kit

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

CBL-460

Purchased

No

100

Each

441.0000

2

8

CBL-460

Loop Sleeve

119690

8a

**

8

(4) FF 12-03-08

Location

Loc Qty

Loc Code

GA

200

119021

200

ST283

13

117947

13

ST284

228

118140

228

D2728-7

Manufactured

No

100

Each

0.0000

0

0

D2728-7

Dart Logo label

D3368-1

Manufactured

No

100

Each

6.0000

1

4

D3368-1

Pedal Lock Base

**

(4) FF 12-03-08

**

(4) FF 12-03-08

Location

Loc Qty

Loc Code

ST490

6

51399

6

4

D3368-3

Manufactured

No

100

Each

3.0000

1

4

D3368-3

Pedal Lock Cover

**

(4) FF 12-03-08

Location

Loc Qty

Loc Code

ST490

3

47343

3

2

D3373-7

Manufactured

No

100

Each

0.0000

1

4

D3373-7

Cam Lock

326212

**

4

(4) FF 12-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Disabling Kit

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3384-1 Manufactured No

100 Each 0.0000 1 4

D3384-1

Cyclic Sock

D3385-3 Manufactured No

100 Each 102.0000 1 4

D3385-3

Hinge

Location

Loc Qty

Loc Code

ST051

102

41 22387

102

HX-81 Purchased No

100 Each 18.0000 1 4

HX-81

1/4"-20 SHCS 3/8" long

Location

Loc Qty

Loc Code

ST390

18

114383

18

12077-3

**

4 (4) FF 12-03-08

**

(4) FF 12-03-08

**

(4) FF 12-03-08

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

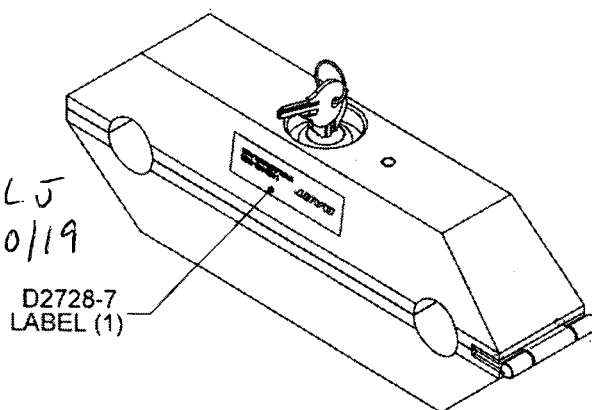
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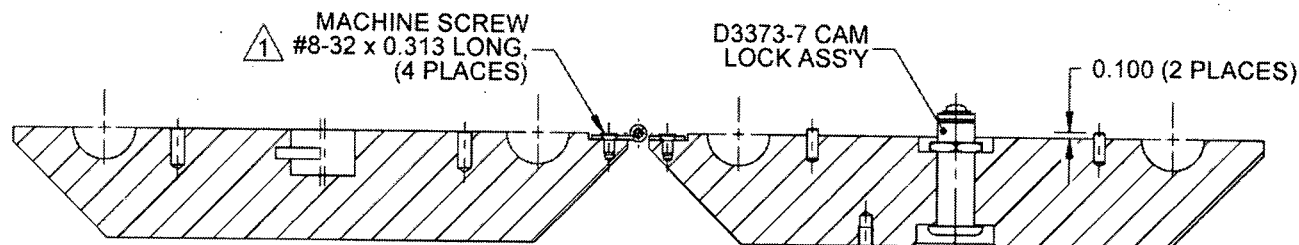
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3368	REV. B
DATE	05.03.22	TITLE PEDAL LOCK	SHEET 1 OF 3
A	05.01.19	NEW ISSUE	SCALE 1:3
B	05.03.22	D3385-3 WAS D3385-1	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75218 M.L.J
11/10/19

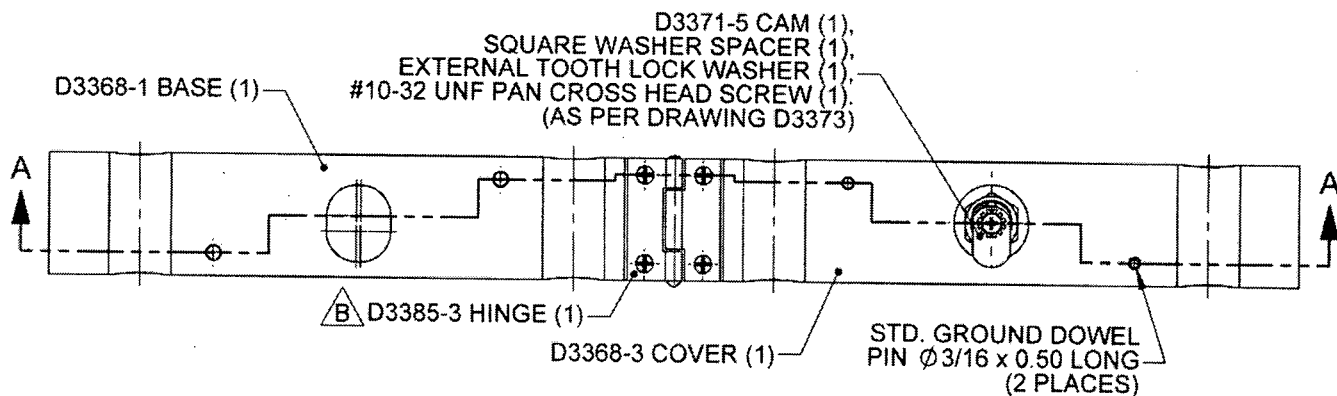


RELEASED
25/04/20

PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAUR P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

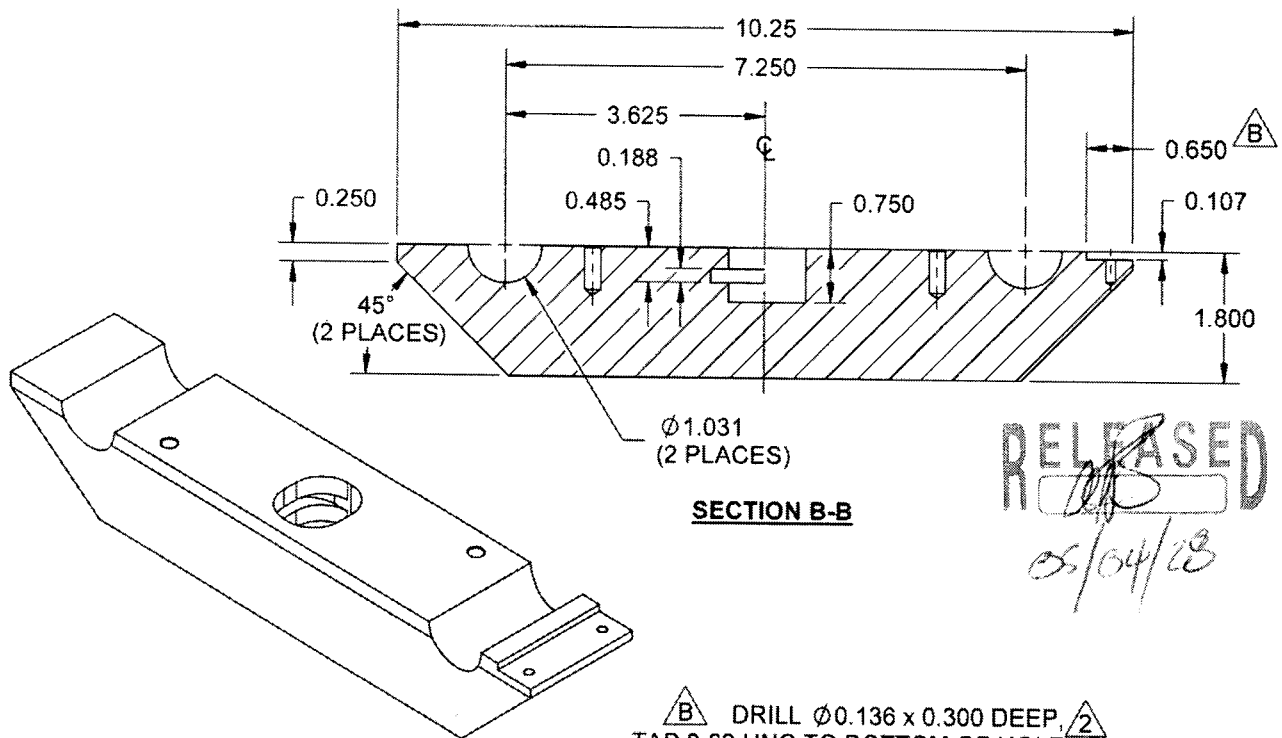
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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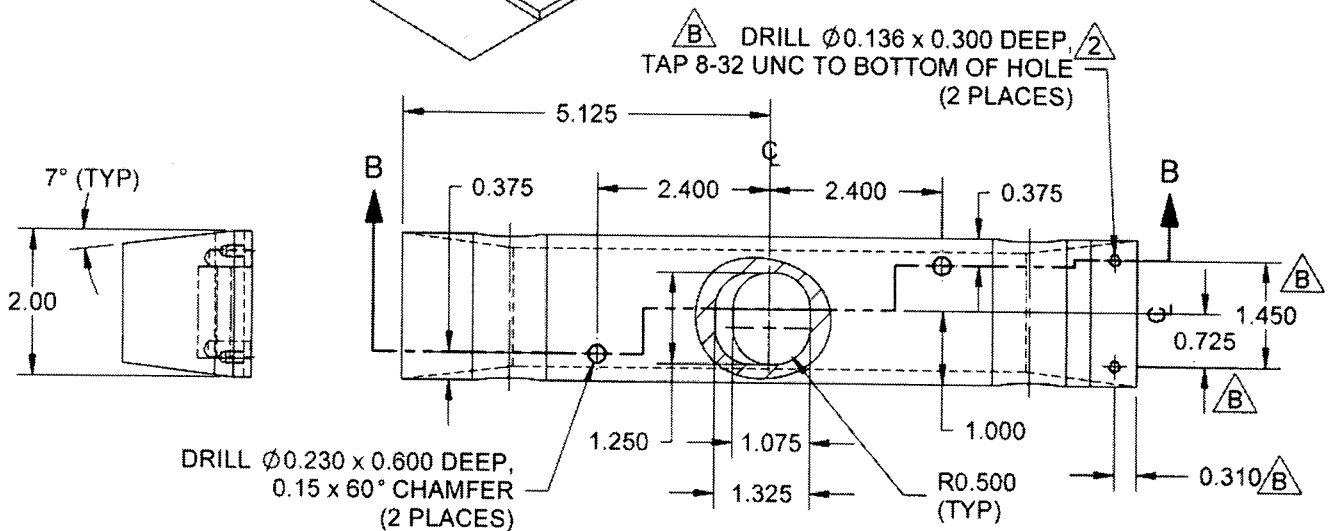
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



RELEASED
[Signature]
05/04/23



DRILL $\phi 0.230 \times 0.600$ DEEP,
0.15 x 60° CHAMFER
(2 PLACES)

D3368-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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81218

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

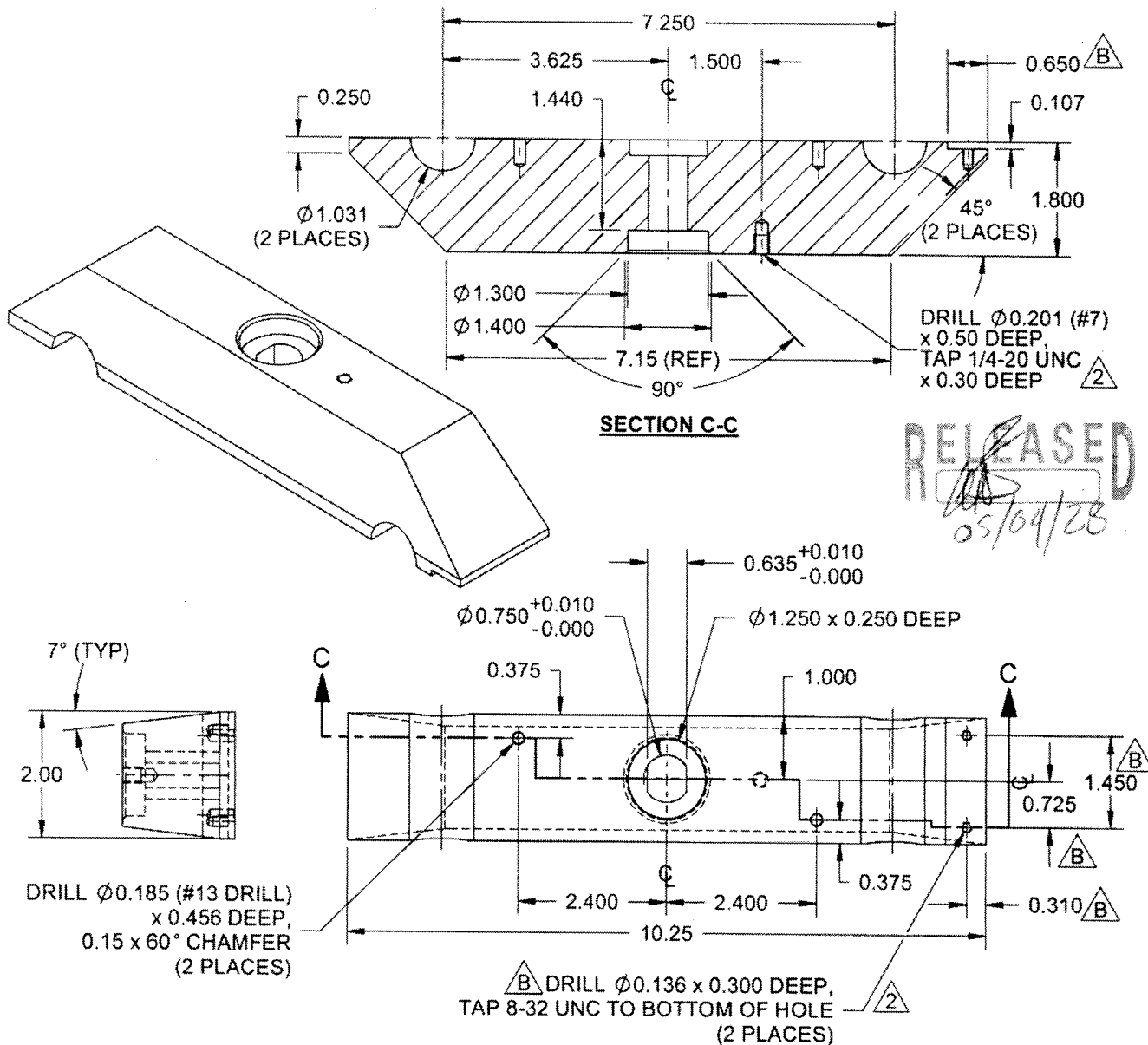
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DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 3 OF 3
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2.5



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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